

Date: Wednesday, 3/26/2008 9:52:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 38162		Part Number	: D353525		
Estimate Number	: 12734		Drawing Number	: D3535 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/26/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	Due Date	Qty:	20	Um:
Previous Run	: 37898		4/1/2008	Each		
Written By	:					
Checked & Approved By	: JD 08.3.27					
Comment	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet 12.316
Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 166748 B 8-3-31		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B B 8-3-31 Prog Rev: B		
2-Deburr if necessary B 8-3-31		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE B 8-3-31
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK S 08/03/31 (x23)
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 S 08/04/02 B 08/04/03 (23)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:52:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 38162

Part Number: D353525

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/04/03 (23)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M 106442



(23)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR 08-04-03

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/04/04 (23)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FD-17

BR 08-04-04 (23)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08 (23)

Job Completion



U 08-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

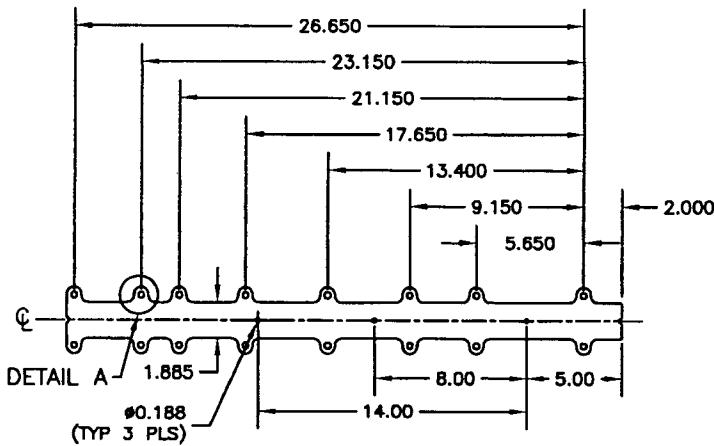
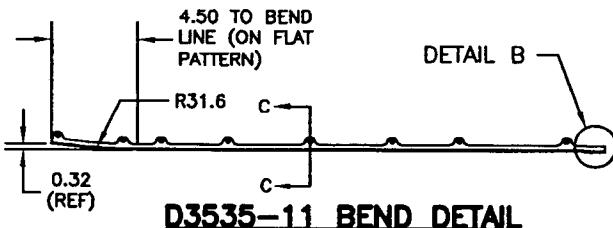
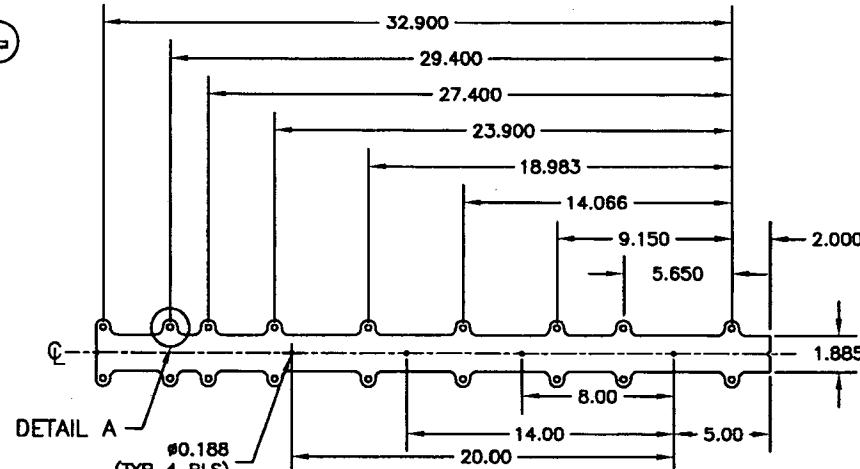
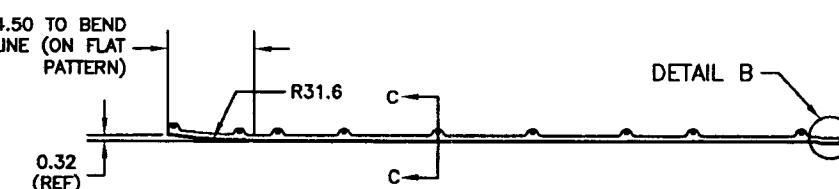
DART AEROSPACE LTD	Work Order:	38162
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	18	Audited by:	18	Prototype Approval:	N/A
Date:	8-3-31	Date:	08/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

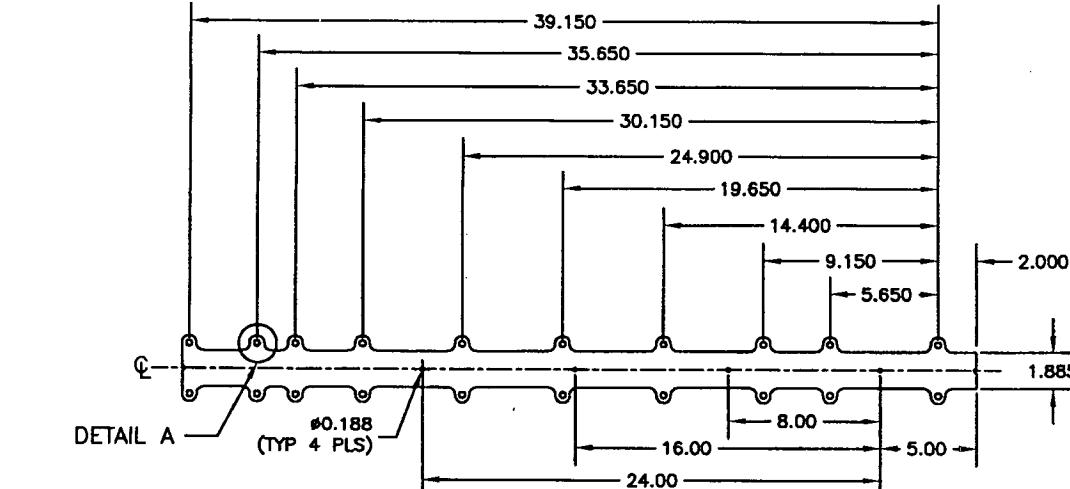
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DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED TH	APPROVED TH	DRAWING NO. D3535	SHEET 1 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10
A		06.10.25 NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

RELEASED
57-04-24



D3535-15F FLAT PATTERN

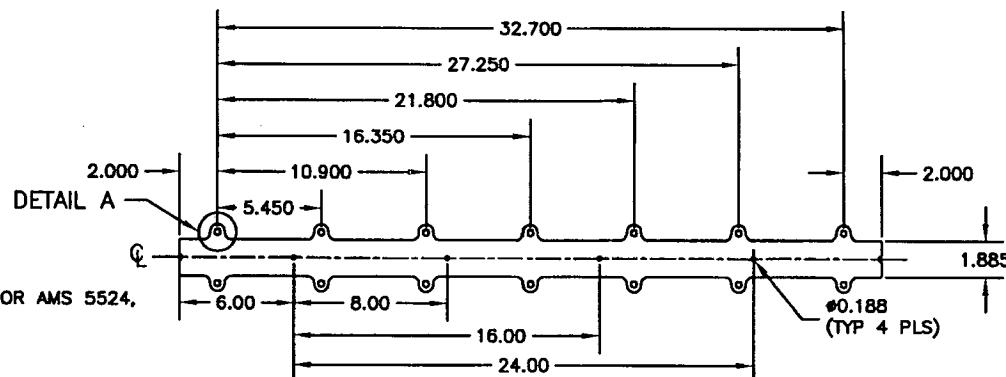
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LINE (ON FLAT
PATTERN)

0.32
(REF)

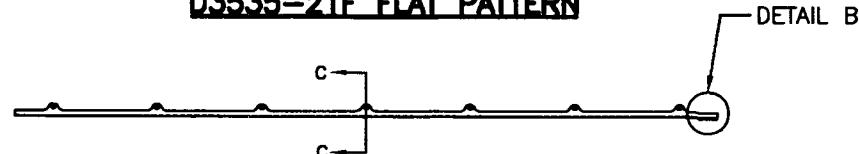
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NOTES

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QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

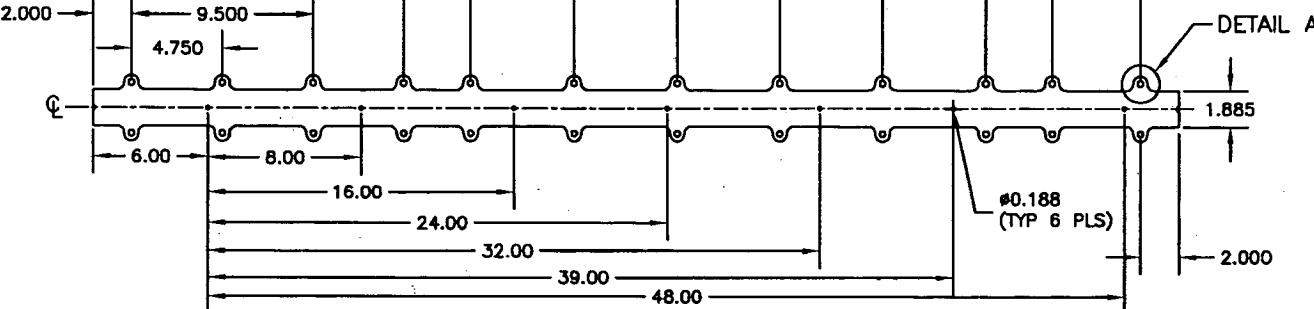
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07.04.24 MM

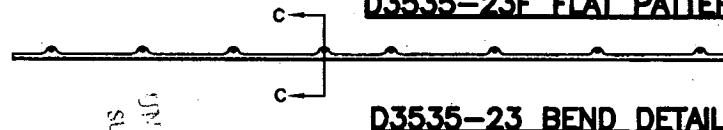
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<u>MM</u>	<u>MM</u>	D3535
DATE		SCALE
07.04.17		1:10
		REV. B
		SHEET 2 OF 7

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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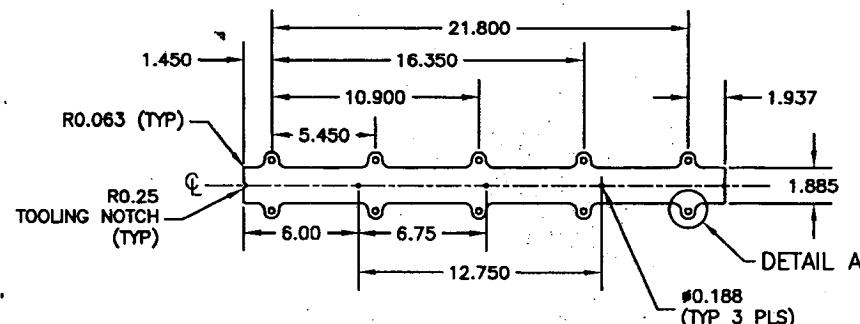


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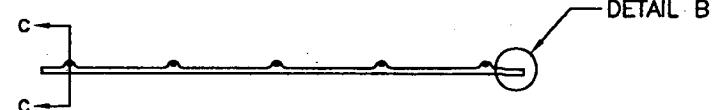


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D3535-25F FLAT PATTERN



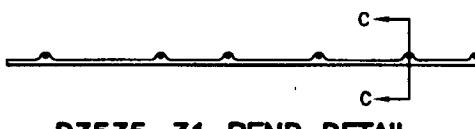
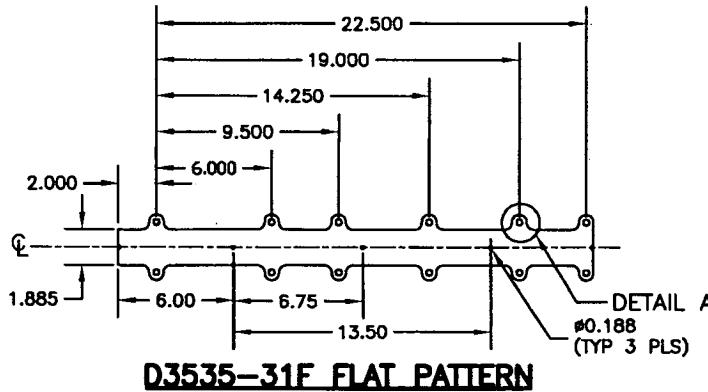
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07.04.17		WEARSHOE
REV. B		SHEET 3 OF 7
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		1:10

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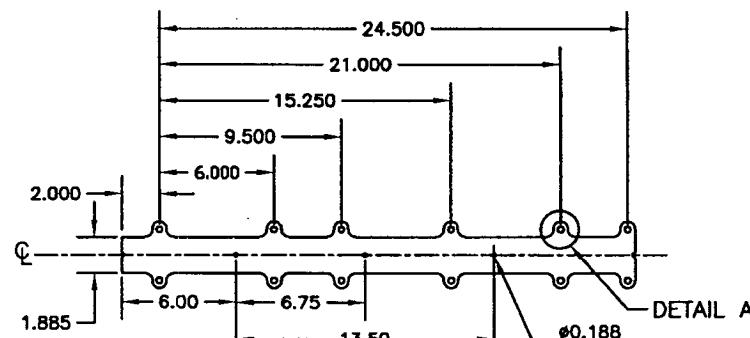
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D3535-31 BEND DETAIL

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

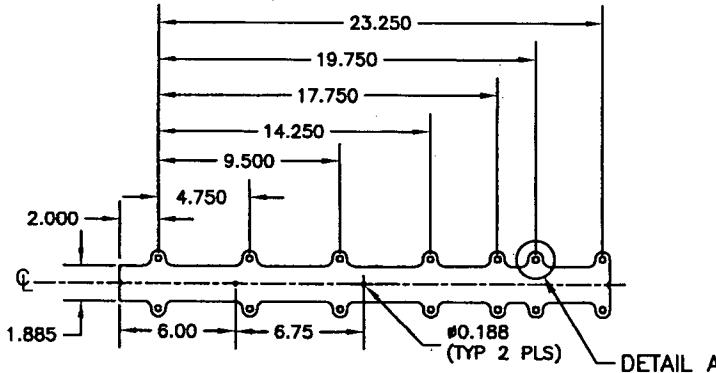


D3535-33 BEND DETAIL

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D3535-35F FLAT PATTERN

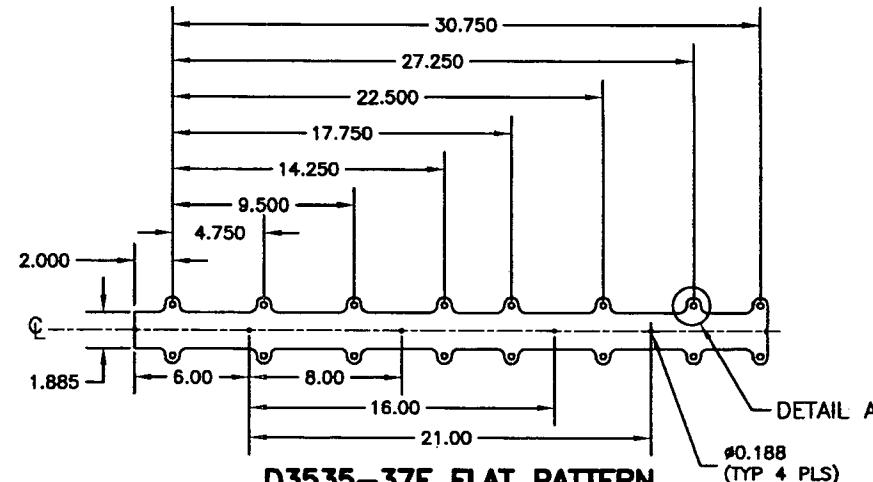


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D3535-37F FLAT PATTERN

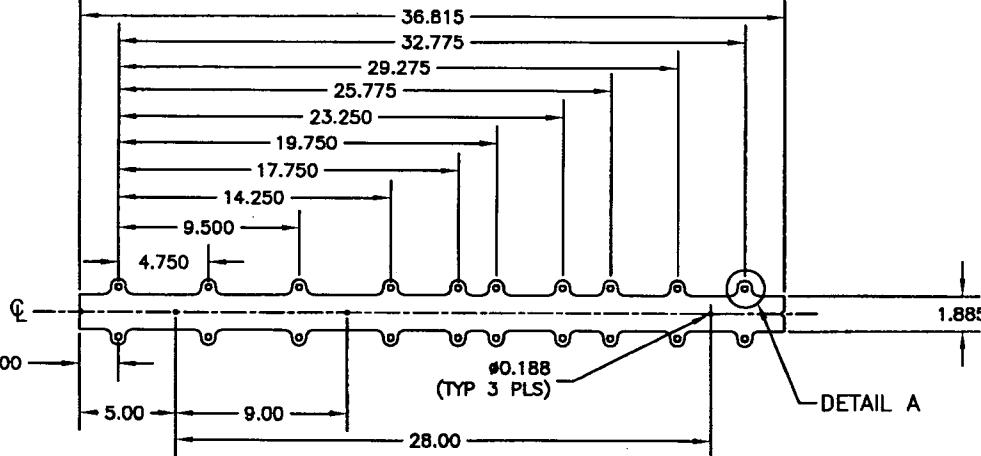


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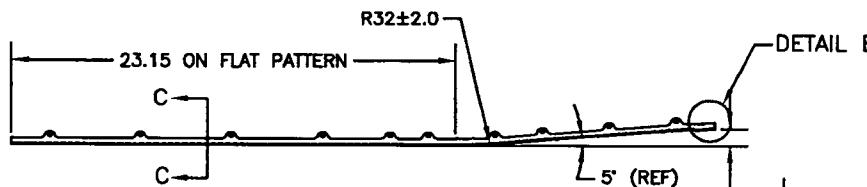
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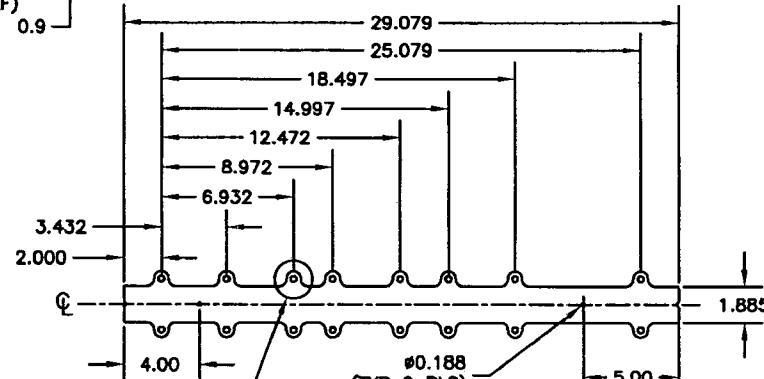


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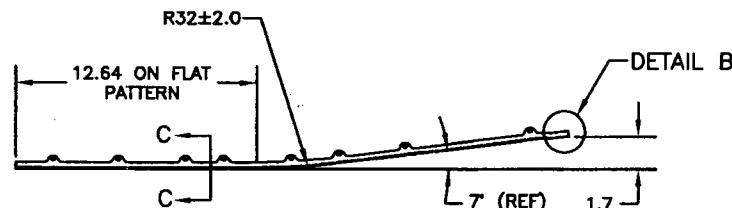
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D3535-41F FLAT PATTERN



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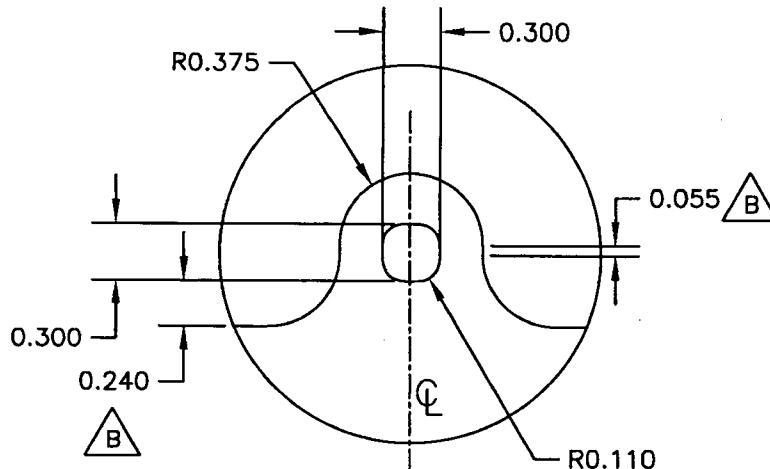
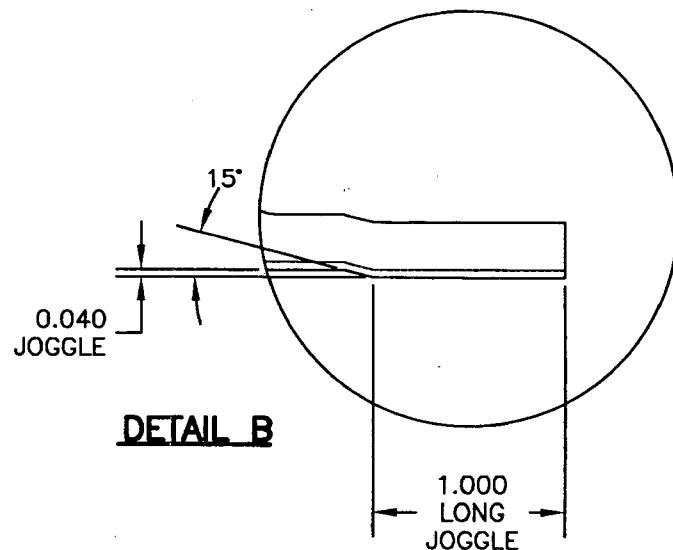
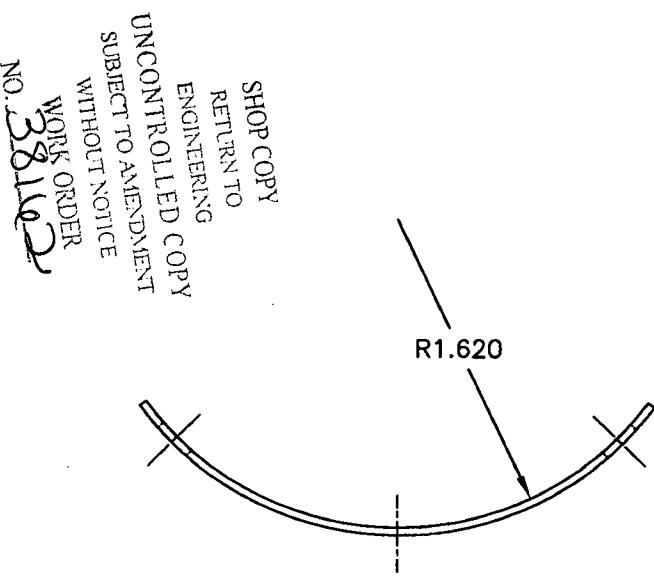
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07.04.24

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DATE 07.04.17	TITLE WEARSHOE	SCALE 1:1	

**DETAIL A****DETAIL B****SECTION C-C**

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